



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2739
Job Sheet 209178



Part No: D2739

Job Qty: 10 pcs

Part Name: 350 I-Beam



Part Weight: 0 lbs

Job Created: 4/16/20

Due Date: 8/31/20

Type: SOLD

Status: New

Priority: Medium

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Note: DWG D2739 REV E IPP Rev: C 02.11.28 Reformat KJ IPP Rev: D 06-03-21 As Per Rev C JLM IPP Rev: E 07-07-28 As per Rev D JLM Verified By: IPP Rev: F 10.11.02 as per revE DD verf: EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
100	Skidtubes - 1	10 pcs	8/29/20		0.00	11.60	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
110	QC 5	10 pcs	8/29/20		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
120	Handfinish - 1-1 Chemical-B4B	10 pcs	8/31/20		0.00	2.00	Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 -		



Container No: S279347



Part: D2739

Job No: 209178

Serial No/Batch: S279347

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.ca
www.dartaerospace.com

Date: 05/26/20

Plex 4/16/20 7:41 AM Dart.lajeunesse.marie

				B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
130	QC 7	10 pcs	8/31/20	0.00 0.00	QC 7 - 10
					QC 7 - 13
					QC 7 - 14
					QC 7 - 15
					QC 7 - 17
					QC 7 - 18
					QC 7 - 19
					QC 7 - 2
					QC 7 - 28
					QC 7 - 3
					QC 7 - 30
					QC 7 - 34
					QC 7 - 36
					QC 7 - 37
					QC 7 - 41
					QC 7 - 47
					QC 7 - 48
					QC 7 - 51
					QC 7 - 58
					QC 7 - 59
					QC 7 - 60
					QC 7 - 9
					QC 7 - 68
					QC 7 - 50
					Plex 4/16/20 7:41 AM Dart.lajeunesse.marie

140 Packaging 3-1 - Stock - B4B

10
pcs

8/31/20

0.00 0.00

QC 7 - 67

QC 7 - 40

QC 7 - 24

QC 7 - 43

QC 7 - 61

QC 7 - 81

QC 7 - 76

QC 7 - 79

QC 7 - 83

QC 7 - 82

QC 7 - 87

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 -
B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 -
B4BPackaging 3 - 13 -
B4BPackaging 3 - 14 -
B4BPackaging 3 - 15 -
B4BPackaging 3 - 16 -
B4BPackaging 3 - 17 -
B4BPackaging 3 - 18 -
B4BPackaging 3 - 19 -
B4BPackaging 3 - 20 -
B4BPackaging 3 - 21 -
B4BPackaging 3 - 22 -
B4BPackaging 3 - 23 -
B4BPackaging 3 - 24 -
B4BPackaging 3 - 25 -
B4BPackaging 3 - 26 -
B4BPackaging 3 - 27 -
B4BPackaging 3 - 28 -
B4BPackaging 3 - 29 -
B4BPackaging 3 - 30 -
B4BPackaging 3 - 31 -
B4BDAS
03
9-89

4/16/2020

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
150	QC 21 - SA	10 pcs	8/31/20	0.00 0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	JUN 04 2020 70
					QC 21 - SA - 53	9-89

Part Op 100 - (Skid tubes) 1-Cut D2600-5 to length as per Dwg D2739. 2-Drill pilot holes in web using drilling Jig DT8162 as per Descriptions: Dwg D2739 3-Use uni-bit to open holes to finish size as per Dwg D2739. 4-Bevel Fwd end of extrusion and Deburr holes and ends.

110 - QC5- Inspect part completeness to step on W/O

120 - (Chemical Conversion Coat per QSI005 4.1)

130 - (QC7- Inspect Chemical Conversion Coat)

140 - (Identify as per dwg & Stock Location: _____) LOCATION : LG002

150 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-5-108	Extrusion I-Beam Thin	10 pcs (1 ea)	100-Skid tubes - 1	S146203

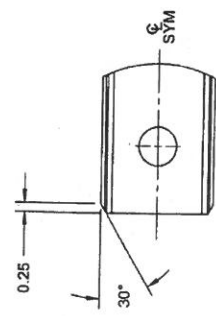
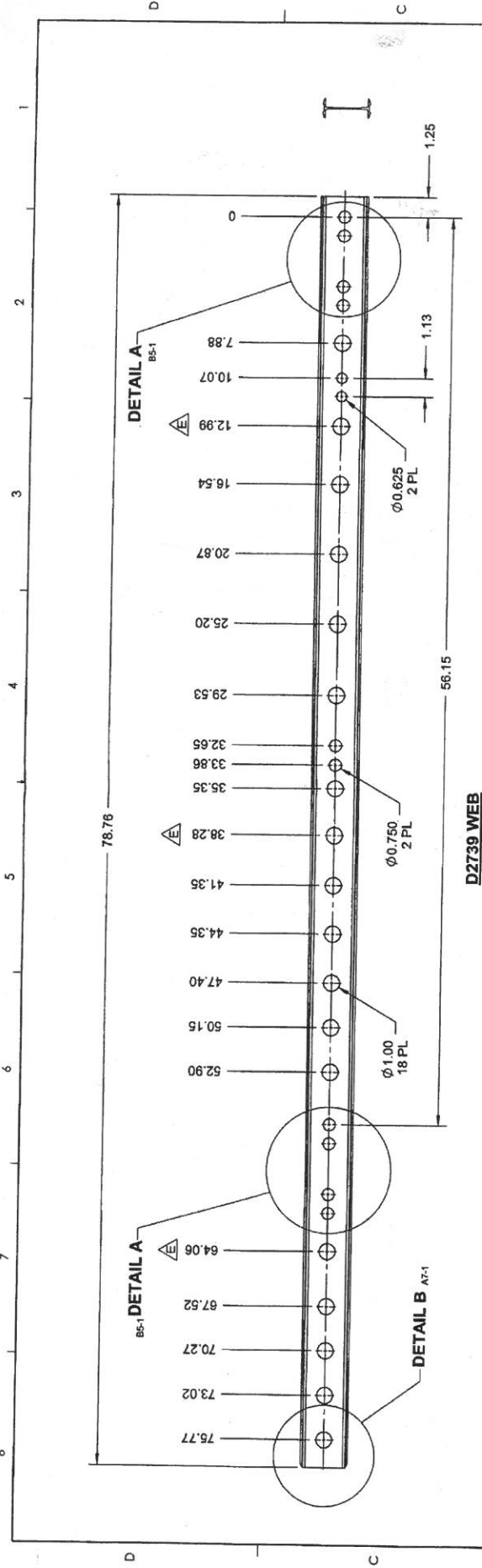
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Skid tubes - 1	D2600-5-108	10	82	0

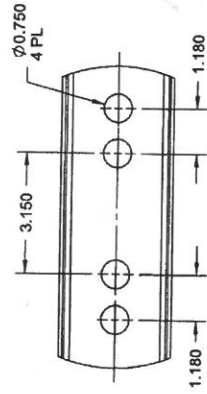
Plex 4/16/20 7:41 AM Dart.lajeunesse.marie

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Web	78.760Inches $\pm$ 0.030	78.790 78.730		
2	Web	1.180Inches $\pm$ 0.010	1.190 1.170		
3	Web	3.150Inches $\pm$ 0.010	3.160 3.140		
4	Web	1.180Inches $\pm$ 0.010	1.190 1.170		
5	Web	0.250Inches $\pm$ 0.030	0.280 0.220		
6	Web	30.000Degrees + 0.500 - 5.000	30.500 25.000	Angle	
7	Web	1.250Inches $\pm$ 0.030	1.280 1.220		
8	Web	7.880Inches $\pm$ 0.030	7.910 7.850		
9	Web	10.070Inches $\pm$ 0.030	10.100 10.040		
10	Web	12.990Inches $\pm$ 0.030	13.020 12.960		
11	Web	16.540Inches $\pm$ 0.030	16.570 16.510		
12	Web	20.870Inches $\pm$ 0.030	20.900 20.840		
13	Web	25.200Inches $\pm$ 0.030	25.230 25.170		
14	Web	29.530Inches $\pm$ 0.030	29.560 29.500		
15	Web	32.650Inches $\pm$ 0.030	32.680 32.620		
16	Web	33.860Inches $\pm$ 0.030	33.890 33.830		
17	Web	35.350Inches $\pm$ 0.030	35.380 35.320		
18	Web	38.280Inches $\pm$ 0.030	38.310 38.250		
19	Web	41.350Inches $\pm$ 0.030	41.380 41.320		
20	Web	44.350Inches $\pm$ 0.030	44.380 44.320		
21	Web	47.400Inches $\pm$ 0.030	47.430 47.370		
22	Web	50.150Inches $\pm$ 0.030	50.180 50.120		
23	Web	52.900Inches $\pm$ 0.030	52.930 52.870		
24	Web	64.060Inches $\pm$ 0.030	64.090 64.030		
25	Web	70.270Inches $\pm$ 0.030	70.300 70.240		
26	Web	73.020Inches $\pm$ 0.030	73.050 72.990		
27	Web	75.770Inches $\pm$ 0.030	75.800 75.740		
28	Web	56.150Inches $\pm$ 0.030	56.180 56.120		

Plex 4/16/20 7:41 AM Dart.lajeunesse.marie



DETAIL B
AT-1
SCALE 3X



DETAIL A
D2-1, D2-1
SCALE 3X

RELEASED
R 2010-11-01

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 209178
2004-16

- NOTES:**
- 1) MATERIAL: MAKE FROM D2600-3 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: DART P/N "D2739" AND BN PER DART QSI 044 6.1
 - 7) WEIGHT: 3.41 lbs

REV.	DESCRIPTION	DS	BY	DATE
E	ADD MOVE HOLES FOR D4154 WEAR PLATE, 38.28 WAS 38.35 (DS-1), 84.06 WAS 84.77 (DS-1), ADD HOLE (DS-1)	CP	DS	10.10.08
D	ADD BEVEL TO FWD END, ADD DETAIL B	CP	DS	07.05.29
C	ADD MOVE HOLES FOR COMPATIBILITY WITH APICAL FLOATS	PH	DS	06.01.05
B	CHANGE HOLES FOR COMPATIBILITY WITH AIRCRAUSER FLOATS	CP	DS	08.11.18
A	NEW ISSUE	DS	DS	08.04.18

DESIGN	DS	DATE
DRAWN	DS	
CHECKED	DS	
MFG. APPR.	DS	
APPROVED	DS	
DE APPR.	DS	
DATE	10.10.08	

DART AEROSPACE USA, INC.	
PORT HADLOCK, VA	
DRAWING NO.	D2739
TITLE	WEB
SCALE	NTS
SHEET 1 OF 1	
REV E	

COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.
THIS DRAWING IS THE PROPERTY OF DART AEROSPACE USA, INC.
IT IS TO BE USED FOR ANY PURPOSE OR FOR ANY OTHER DRAWING WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

DISPOSITION		DEPARTMENT/PROCESS			
Job: _____	☐ Rework ☐ Scrap ☐ Use-as-is	☐ Skid-tube Machining ☐ Large Fab	☐ Cross tube Small Fab ☐ Finishing	☐ Eng. (Non-AW) Prod. Eng. Coord. ☐ Rec/Store/Packaging	☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS1042)	
Description Work Order Deviation		Disposition			
		Completed By			
		Lead hand / Supervisor			
		QC / QA Coordinator			
Root Cause		FAULT CATEGORY			
☐ Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors		☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function			
☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled Other/Details: _____		☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up			
		☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			